

Work Order ID 73698

Tuesday, September 13, 2011 12:33:31 PM



WUC

Page 1

Item ID: D3859-041

Accept



Setup Start



Revision ID:

Item Name: Wearplate

Stop



Start Date: 9/13/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 9/20/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: MF Date: 11-09-13

Tooling:

Date:

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3859 ☒ Dwg Rev: A ☐ Prog Rev: A ☐ 2-
Deburr if necessary

304 .063

B 11-9-13

8

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B 11-9-13

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8/10/14

(X8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Weld D3009-3 cups as per dwg D3859 ☐ A/R 316L stainless steel rod
Batch: M114509 ☐ 2-Weld hard facing as per Dwg D3859 ☐ A/R
2059B Hard Coat rod Batch: M118453 ☐ *****use
DT9462 for welding*****

EL 11-9-20 X8

140

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

Cpl 11-09-21

150

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8-11-09/21

X8

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

170

QC3- Inspect Part Finish

0.00



QC

Memo

Quality Control

180

Identify as per dwg & Stock Location: 500

0.00



Packaging

Memo

Packaging

8x Ø m-f 11/04/22

8 BL 11-9-22

11/9/23 SLD

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/9/27

UMF

11-09-23

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Picklist Print

Tuesday, September 13, 2011 12:33:29 PM

Page 1

Work Order ID: 73698

Parent Item: D3859-041

Parent Item Name: Wearplate



Start Date: 9/13/2011

Required Date: 9/20/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A 09-02-03 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA  304/316 Sheet .063		Purchased	No			100	sf	65.7000	0.85	6.8			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT020		65.7							
				118578		65.7							
D3009-3  Cup		Manufactured	No			130	Each	11.0000	6	48			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		6							
				72194		6							
				WA030		5							
				42377		5							
										73699	37		

B11-9-13

118217

(8)

12 11-9-19

6

5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

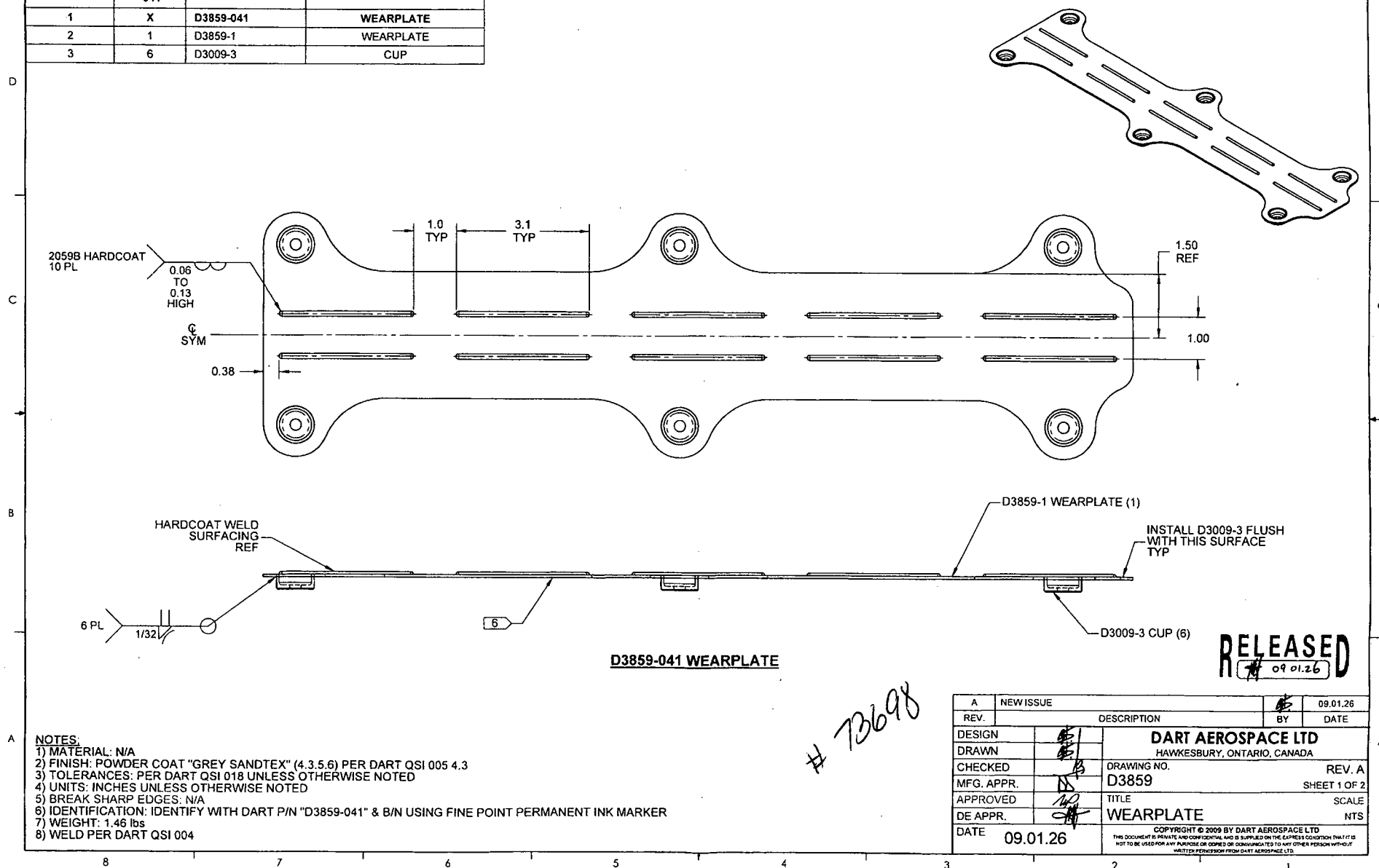
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D3859-041	WEARPLATE
2	1	D3859-1	WEARPLATE
3	6	D3009-3	CUP



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3859-041" & B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.46 lbs
- 8) WELD PER DART QSI 004

RELEASED
09 01.26

A	NEW ISSUE		BY	09.01.26
REV.		DESCRIPTION		DATE
DESIGN				
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	09.01.26			

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. A
D3859 SHEET 1 OF 2
TITLE SCALE
WEARPLATE NTS

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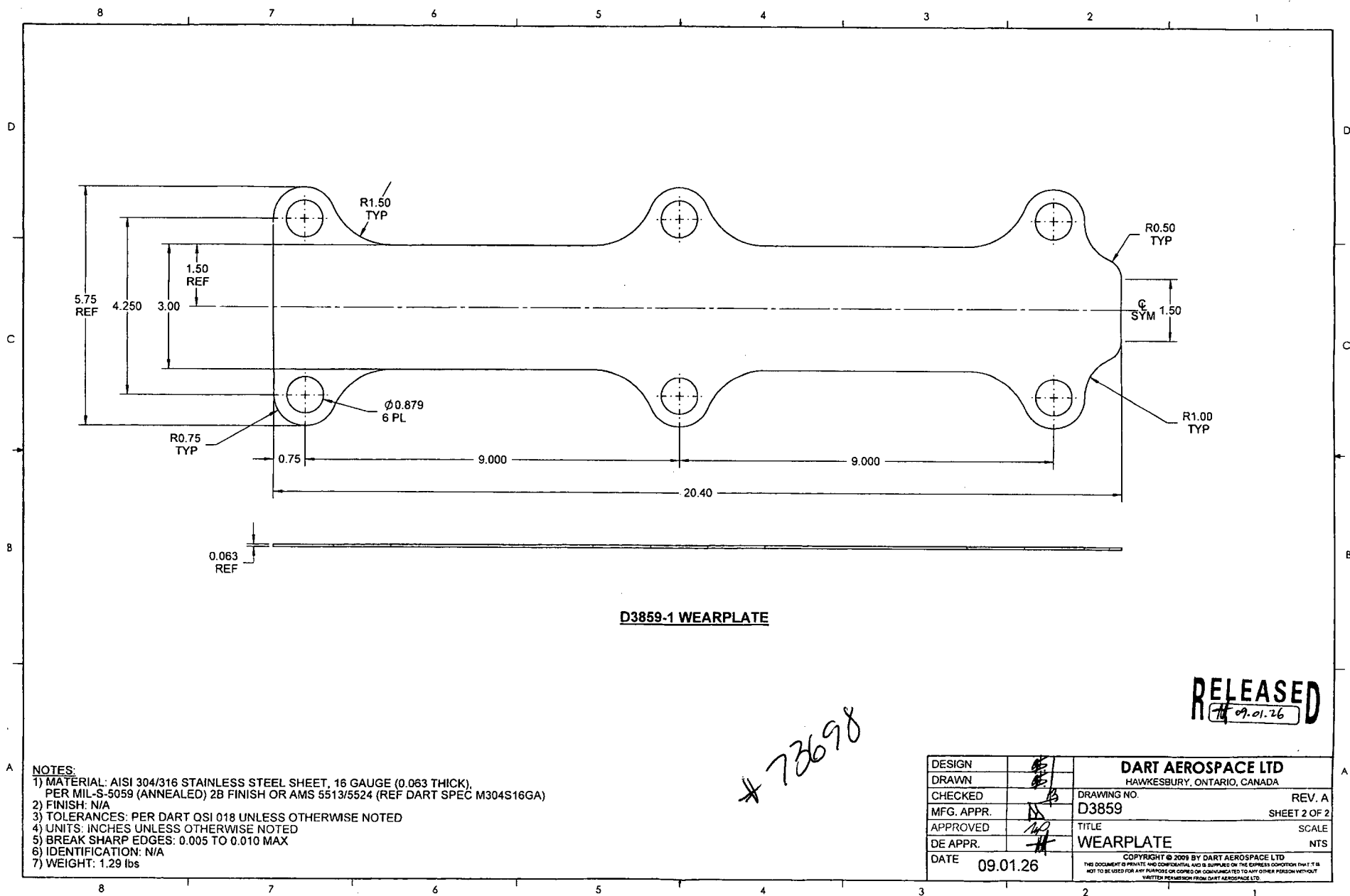
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